

30/03

FAASA 719 MIRRORS

Dart Aerospace Ltd.

Date: Tuesday, 04/03/2008 10:49:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL CARGO MIRROR ASSY
 Job Number : 37598
 Estimate Number : 13191
 P.O. Number :
 This Issue : 04/03/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D119696043
 First Issue : 11 Type : SMALL / MED FAB Drawing Number : D3074
 Previous Run : 37598 Drawing Revision : A
 Written By : Material :
 Checked & Approved By : Due Date : 30/03/2008 Qty: 13 Um: Each
 Comment : Est Rev:A 08-02-19 New issue DD verified by: LL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 3.4997 f(s)/Unit Total : 45.4955 f(s)
 304 RD Tube .500 x .035W
 Material: AISI 304/316 SS tube Ø 0.50 x 0.035" wall

Batch M107403 (2)
 M107166

2.0 D2054 Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 26.0000 Each(s)
 Bushing - Delrin
 batch 31219

3.0 D2055 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 26.0000 Each(s)
 Clamp
 batch B34365

4.0 D2056 Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s)
 Bell Crank Assembly
 batch B31220

5.0 D30721 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s)
 Bracket
 batch B6285 7X B37685

Grand Total (hrs.)

198.44 162.98

Date: Tuesday, 04/03/2008 10:49:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL CARGO MIRROR ASSY

Job Number: 37598

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30722

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 13.0000 Each(s)

Bracket

batch

316286

7X

B37626

6X

[Handwritten signature]

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- punch one side

2- slide parts in tube

3- punch other side

4- bend as per dwg D3074

5- drill holes as per dwg D3074

6- deburr and polish

[Handwritten notes: SB 08/03/10]

[Handwritten notes: FF 08-03-11]

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Handwritten notes: 08/03/25 +13]

9.0

D2011101

Mirror 6"



Comment: Qty.: 2.0000 Each(s)/Unit Total: 26.0000 Each(s)

Mirror 6"

batch

37326

[Handwritten signature]

10.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 78.0000 Each(s)

Washer

batch


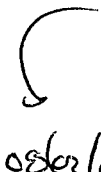



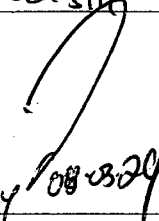

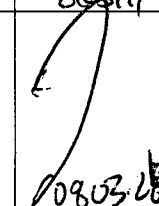
106552

[Handwritten notes: 8/3/06 (13)]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D119-696-043 PAR #: N/A Fault Category: Prod / Pass ^{mal + small} NCR: Yes No DQA: D Date: 08/03/06
 QA: N/C Closed: D Date: 08/03/06

NCR: 37598		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/11	7	mirror arm damaged by bending process L.C. Hammer error (no stang)		Destroyed and replaced with B# 107166 QTY 1	FF 08/03/11			
08/03/24	7	2 pieces mirror arm damaged by trying the new jig R.C: Sig plates were no good.		Keep parts + destroyed + replaced mirror arm correct drill sig.	SB 08/03/24 08/03/24			

NOTE: Date & initial all entries

Date: Tuesday, 04/03/2008 10:49:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL CARGO MIRROR ASS'Y

Job Number: 37598

Part Number: D119696043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 39.0000 Each(s)

Nut

batch

106242

[Handwritten signature]

12.0

MS27039118

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 39.0000 Each(s)

Screw

batch

162339

9X

M106112

30

[Handwritten signature]

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3074

FF 08-03-26

(13)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 0803/26 (13)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

BIP 37589

[Handwritten signature]

8/3/26

(13)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 0803/26

11 08-03-26

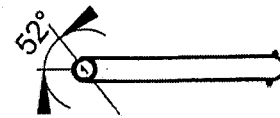
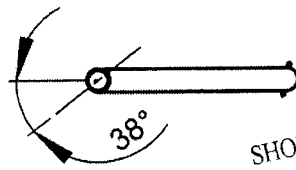
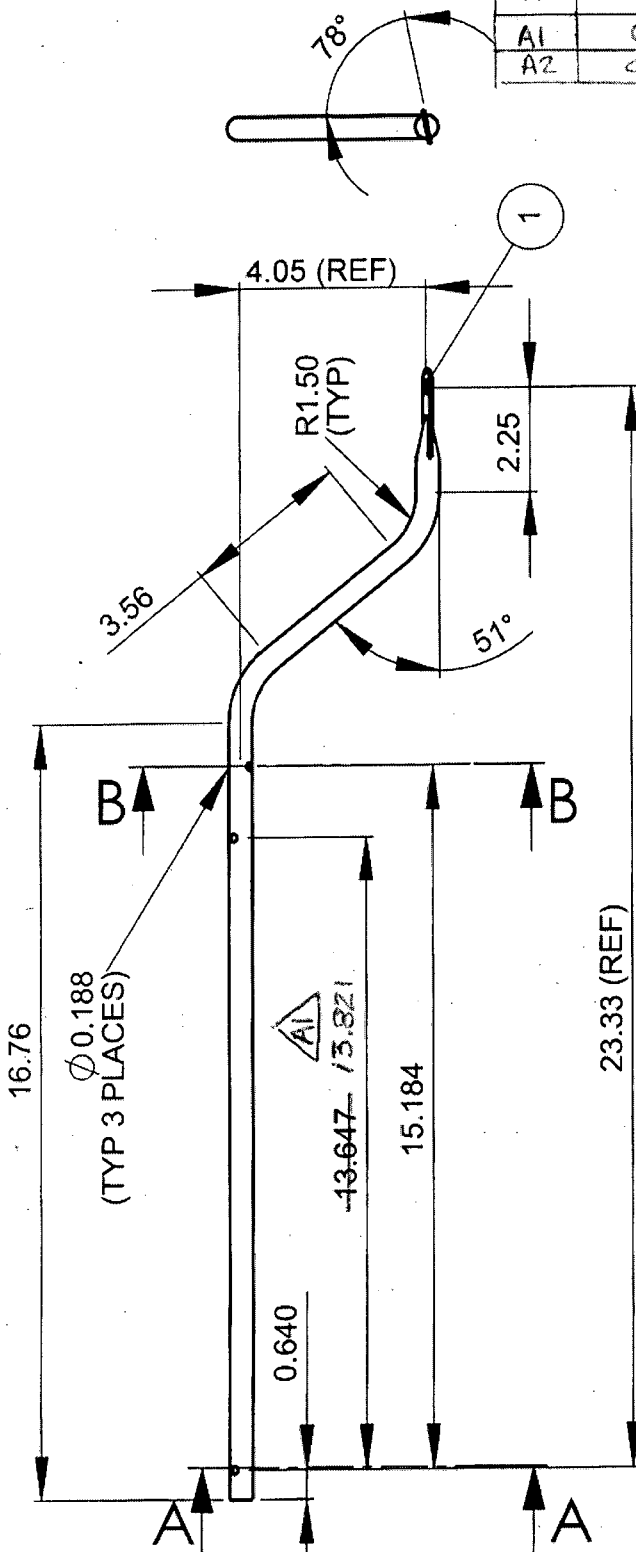
Job Completion





DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3074	REV. A SHEET 1 OF 2
DATE	01.12.17			TITLE ARM	SCALE 1:4
A	01.12.17			NEW ISSUE	
A1	02.01.15			13.821 WAS 13.647 CP#	
A2	02.03.22			ADD FINISH CP#	



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 37637

SECTION B-B
(1 PLACE)
SECTION A-A
(TYP 2 PLACES)

RELEASED
02.01.15

D3074-1

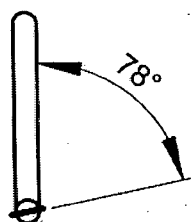
- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FINISH: POWDER COAT BLACK SANDTEX (4.35.7) PER DART QSI 005 4.3 (A2)

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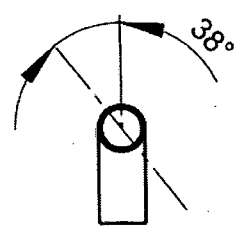
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DART

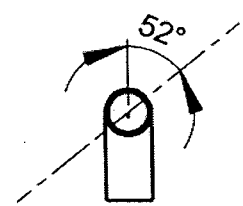
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CHECKED	APPROVED	DRAWING NO.	REV. A
		D3074	SHEET 2 OF 2
DATE		TITLE	SCALE
01.12.17		ARM	1:4



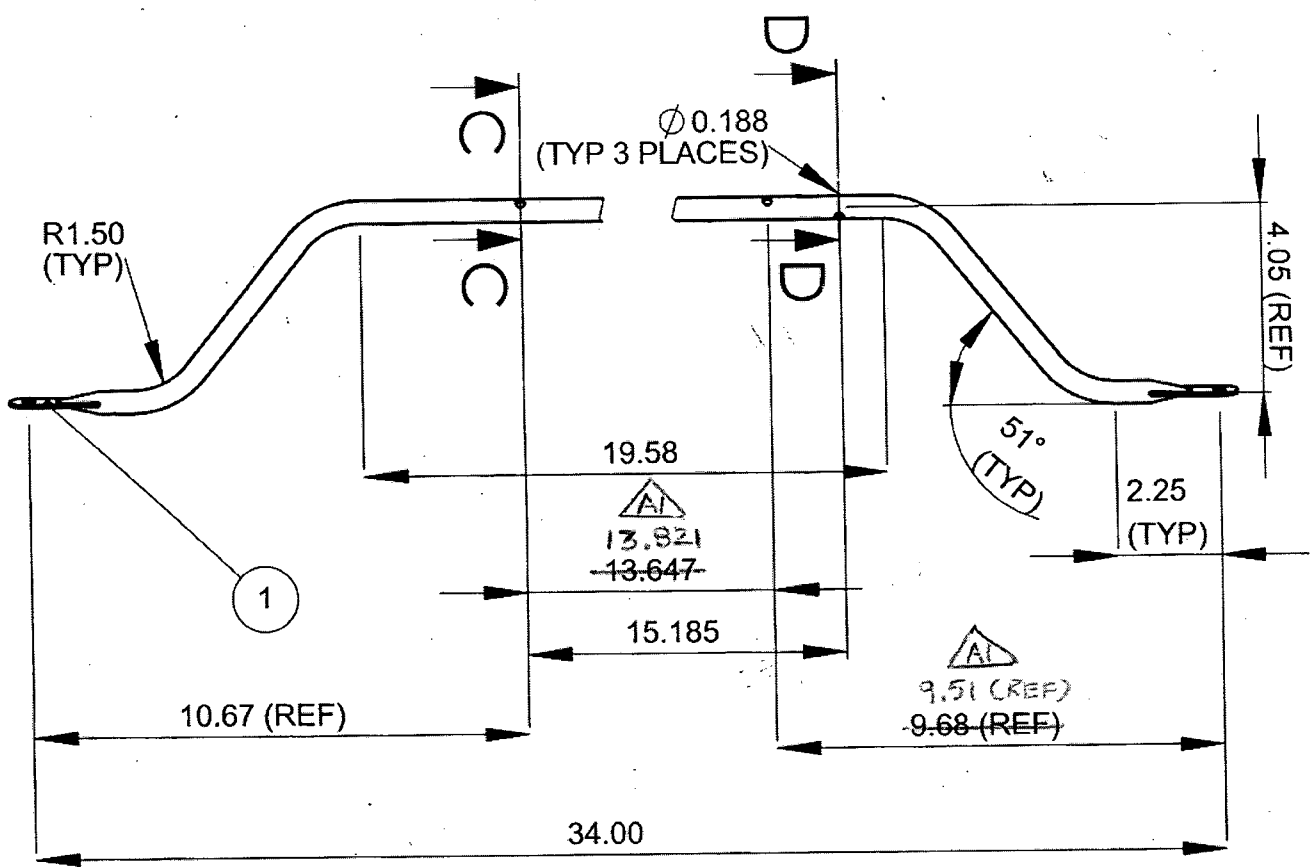
RELEASED
02-01-15



SECTION D-D (1 : 2)
(1 PLACE)



SECTION C-C (1 : 2)
(TYP 2 PLACES)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 37637

D3074-3

- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\varnothing 0.50 \times 0.035$ WALL
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

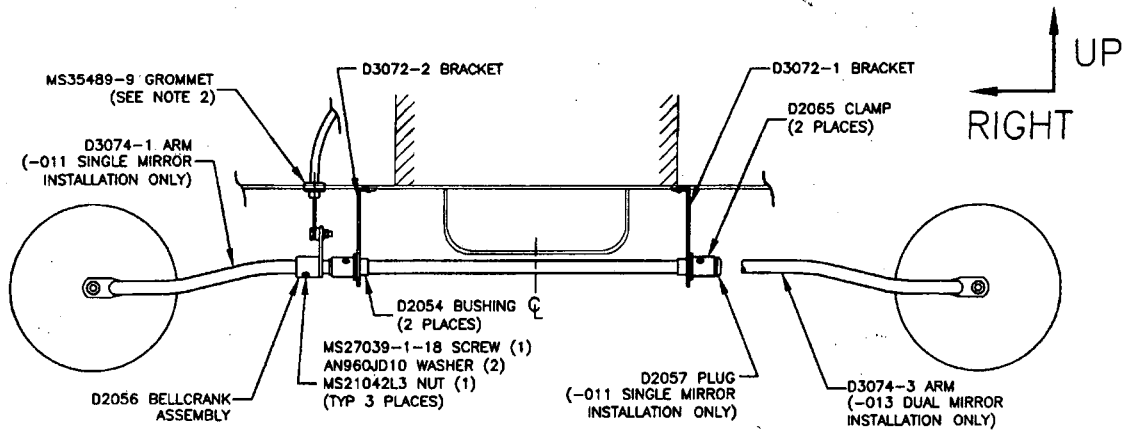


Figure 25-2 – View A: Looking Aft
(D119-696-011/-013 Mirror Shown)

REFERENCE ONLY

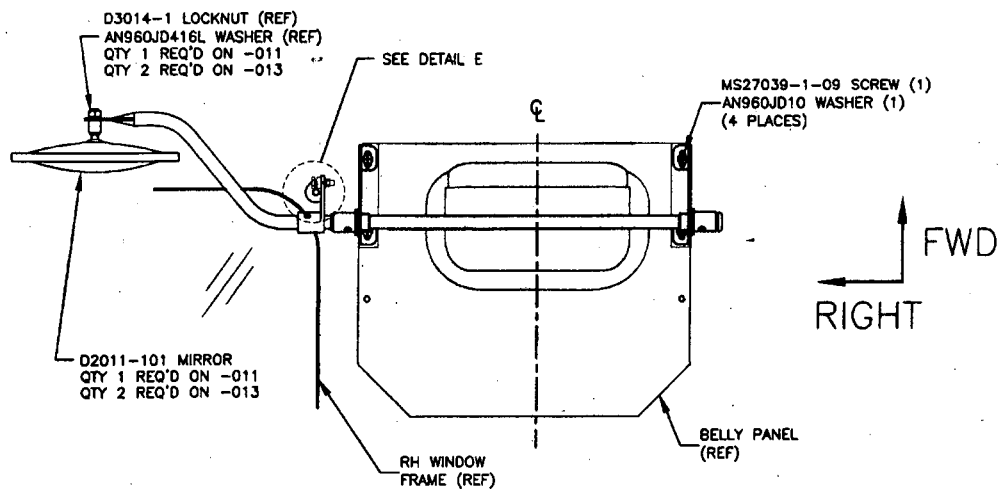


Figure 25-3 – View B: Looking Up
(D119-696-011 Mirror Shown, -013 similar)

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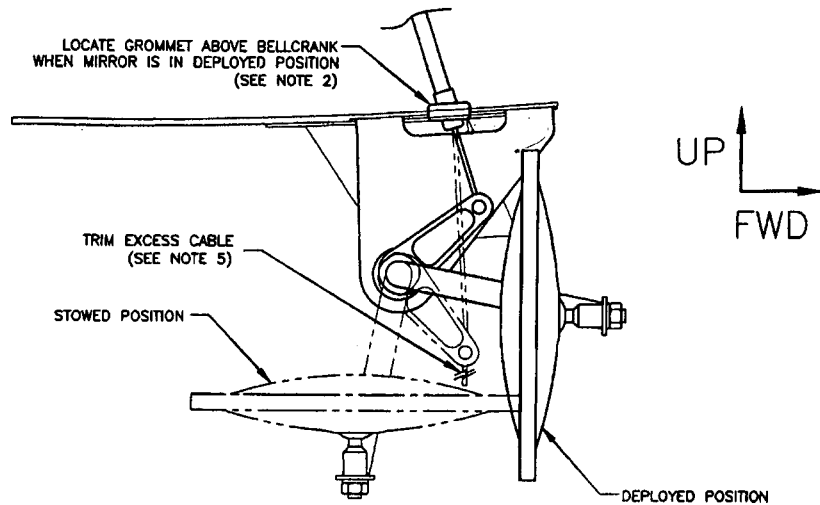


Figure 25-4 – Detail C: Side View of Mirror Deployment
(D119-696-011/-013 Mirror Shown)

REFERENCE ONLY

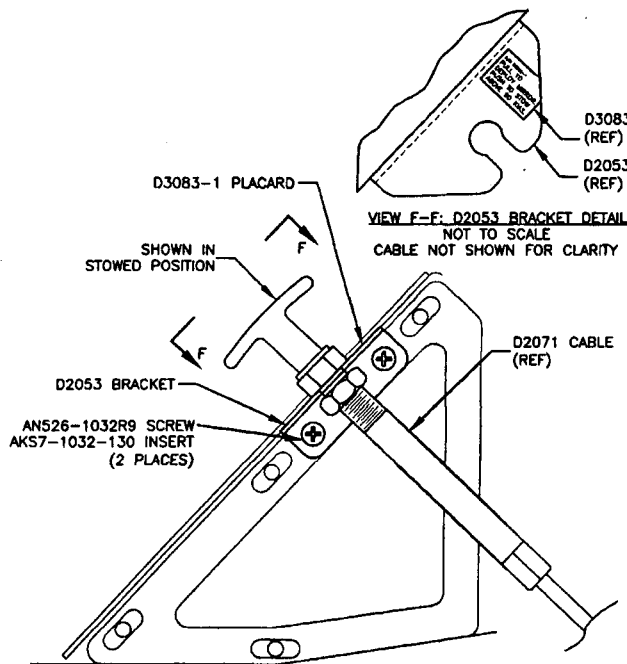


Figure 25-5 – Detail D
Control Panel Attachment
(D119-696-011/-013 Mirror Shown)

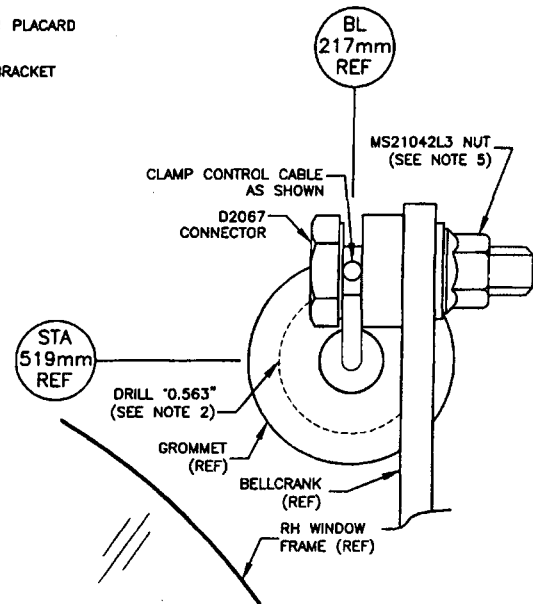


Figure 25-6 – Detail E
Bellcrank/Cable Attachment
(D119-696-011/-013 Mirror Shown)

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